

Work Order ID 54529

December 10, 2009 3:46:43 PM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Item Name: 206 (24") Bearpaw

Stop



Start Date: 10/12/2009 Start Qty: 16.00



Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan:

AL

Date:

09-12-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2432

Rev F3

120



FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

B 9-12-16

(16)

130



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Debur

mmf

09/12/21

DA 09/12/22

(16)

140



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

mmf

09/12/21

DA 09/12/22

(16)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 54529

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Page 2

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 10/12/2009 Start Qty: 16.00

Required Date: 18/12/2009 Req'd Qty: 16.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

SPC 12/22

16 0

Quality Control

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPP 54527 4P
PPN 54528 12P 12/23

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12-23

C209112123

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

December 10, 2009 3:46:48 PM

Page 1

Work Order ID: 54529

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw

Comments:

Start Date: 10/12/2009

Required Date: 18/12/2009

Start Qty: 16.00

Required Qty: 16.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

MUHMWB10

Purchased

No

120

sf

383.3041

59.2000



UHMW 1" Black

B 9-12-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

341.2164

112186

122.0164

112514

11.2

113166

208

Main Warehouse

ST

42.0877

111354

42.0877

113166

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

| | | |
|----|----------|---------------------------------|
| F1 | 49.03.03 | ADD DEO 9143 |
| F2 | 01.03.28 | Ø0.93 WAS Ø0.75 RF |
| F3 | 02.01.23 | CLARIFY CORE DIMS RF |

RELEASED
98.06.17 KE

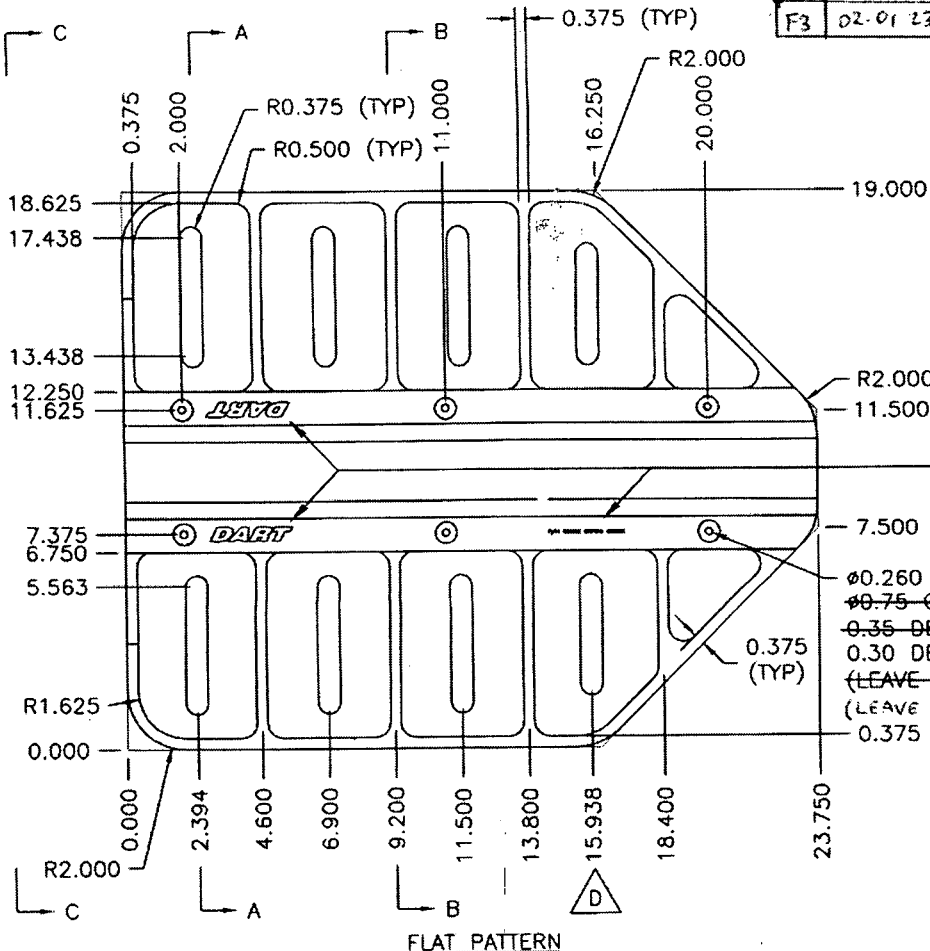
DART

54529
R09-12-10

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

| DESIGN | | DRAWING BY | | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | |
|----------|----------|----------------------------------|-------|---|--|
| KE | | KE | | | |
| CHECKED | APPROVED | DRAWING NO. | | REV. F | |
| MM | KE | D2432 | | SHEET 1 OF 2 | |
| DATE | TITLE | | SCALE | | |
| 98.05.12 | BEARPAW | | 1:6 | | |
| A | 95.10.31 | NEW ISSUE | | | |
| B | 96.01.24 | RE-DESIGN | | | |
| C | 96.03.26 | CHANGE BORE AND C'BORE DEPTH | | | |
| D | 96.06.04 | MOVE SLOT | | | |
| E | 97.02.27 | CHANGE C'BORE DEPTH, BORE RADIUS | | | |
| F | 98.05.12 | CHANGE C'BORE, ADD B AND F P/N | | | |

| EFFECTIVE | DEOS |
|-----------|------|
| 9143 | |



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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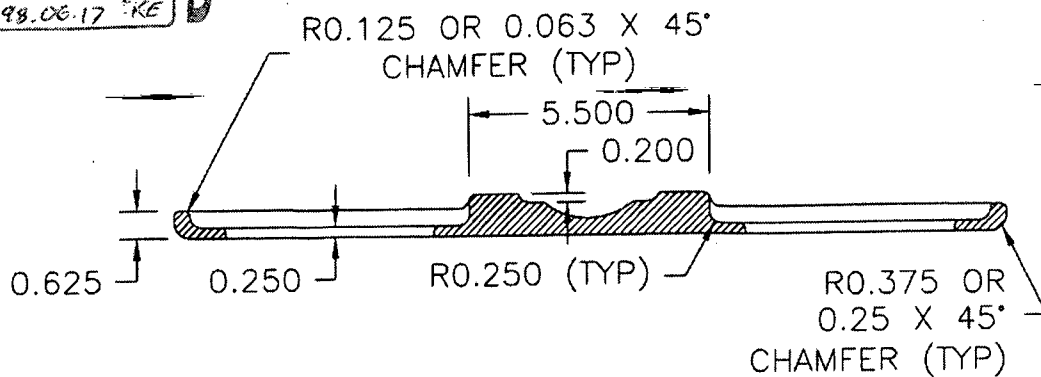
NOTE: Date & initial all entries



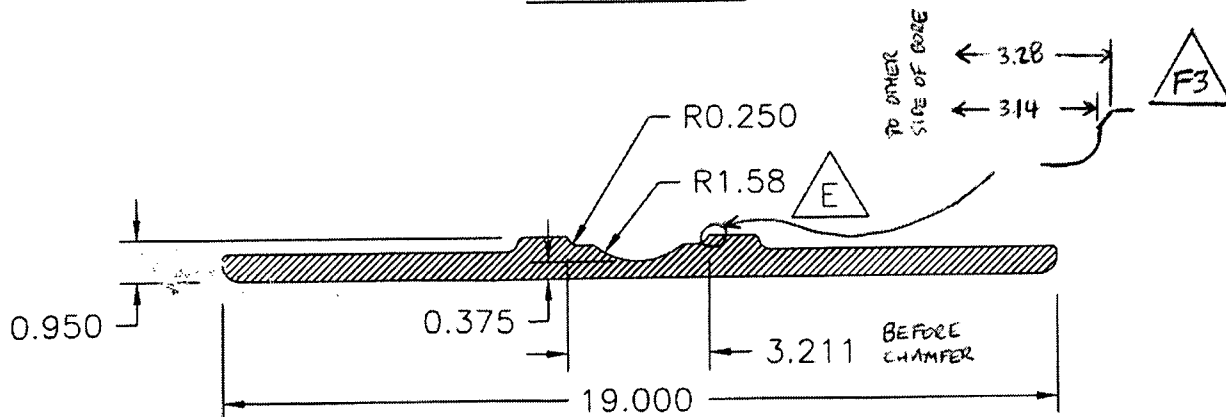
| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN KE | DRAWN BY KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2432 | REV. F SHEET 2 OF 2 |
| DATE 98.05.12 | TITLE BEARPAW | | SCALE 1:4 |

W/D 54529

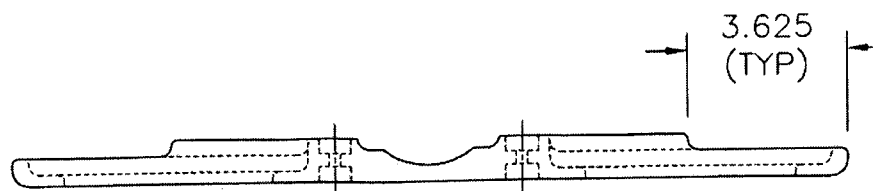
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98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod.Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

| | | |
|------------------------------|----------------|---------------------------|
| DART AEROSPACE LTD | | Work Order: 54529 |
| Description: Bearpaw | | Part Number: D2432 |
| Inspection Dwg: D2432 | Rev: F3 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-------------|---------------------|---------------|--------|-------------------------|----------|
| A | 0.063 x 45° | +0.030/-0.010 | 0.063 x 45° ✓ | | | |
| B | 5.500 | +/-0.030 | 5.504 ✓ | | | |
| C | 0.200 | +/-0.030 | .198 ✓ | | | |
| D | 0.25 x 45° | +/-0.030 | .25 x 54° ✓ | | | |
| E | R0.250 | +/-0.030 | R.250 ✓ | | | |
| F | 0.250 | +/-0.010 | .255 ✓ | | | |
| G | 0.625 | +/-0.030 | .627 ✓ | | | |
| H | 0.375 | +/-0.010 | .379 ✓ | | | |
| I | 0.950 | +0.030/0.010 | .954 ✓ | | | |
| J | 19.000 | +/-0.030 | 19.00 ✓ | | | |
| K | 3.14 | +/-0.030 | 3.143 ✓ | | | |
| L | 3.28 | +/-0.030 | 3.29 ✓ | | | |
| M | Ø0.260 | +0.005/-0.000 | Ø.260 ✓ | | | |
| N | Ø0.93 | +/-0.030 | Ø.92 ✓ | | | |
| O | 0.30 | +0.030/-0.000 | .299 ✓ | | | |
| P | 23.750 | +/-0.030 | 23.750 ✓ | | | |
| Q | 7.375 | +/-0.030 | 7.380 ✓ | | | |
| R | 4.250 | +/-0.010 | 4.258 ✓ | | | |
| S | 2.000 | +/-0.030 | 2.016 ✓ | | | |
| T | 9.000 | +/-0.010 | 9.000 ✓ | | | |
| U | 9.000 | +/-0.010 | 9.000 ✓ | | | |
| V | 0.375 | +/-0.010 | .380 ✓ | | | |
| | | | | | | |
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| | | |
|-------------------------|-----------------------|--------------------------------|
| Measured by: MMF | Audited by: SB | Prototype Approval: N/A |
| Date: 09/12/21 | Date: 09/12/22 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-------------------------|----------|
| A | 04.01.09 | New Issue | P/O K10008/D206-559-015 | KJ/RF |